

Date: Friday, 30/05/2008 10:12:29 AM  
User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CABLE GUARD
Job Number	: 39593		
Estimate Number	: 12458		
P.O. Number	:	Part Number	: D29165
This Issue	: 30/05/2008 S.O. No. :	Drawing Number	: D2916 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 37555	Material	:
Written By	:	Due Date	: 10/06/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUP 08.5.30</u>		
Comment	: Est Rev:A New Issue 06-06-19 JLM Est Rev:B Now water jet 06-07-14 EC		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

MUHMB10

UHMW 1" Black



Comment: Qty.: 0.4200 sf(s)/Unit Total : 4.2000 sf(s)

UHMW 1" Black

batch: 108013 IB 8-6-5

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2916

Dwg Rev: BProg Rev: BIB 8-6-5

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

BATCH: 1080131- Mill as per Folio FA2916-5 Rev: A & Dwg D2916 Rev: B






2-Deburr per dwg D2916

SA 08/06/24

Dart

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2916-5 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: AD Date: 08/07/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 39593		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/06/25	4.0	- 1 part pulled up while machining.  RC: New Process		- Try being turned up during knizen. - Scrap Qty 1 - no replace.	 08/06/25	 08/06/25		 08/06/25

NOTE: Date & initial all entries

Date: Friday, 30/05/2008 10:12:29 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services \

Drawing Name: CABLE GUARD

Job Number: 39593

Part Number: D29165

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



B70  
→

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

21 08/06/24

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28 08/06/25

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 207

8/6/25

8x

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/0198

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-30

H:\FORMS\ID

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2916-5 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: A Date: 08/07/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>395A3</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.06.25	5	Qty (1) Section B-B. Dim 0.14" is 0.03"  RC Part pulled up  Dartway Machine New Process	<u>RA</u> 08.06.25 QSI 042	Recommend scrap. premature wear and inferior product  no replace	<u>SD</u> 08/06/25	<u>S</u> 08/06/25	<u>RA</u> 01.08.25 QSI 042	<u>S</u> 08/06/25

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39593
<b>Description:</b> Cable Guard		<b>Part Number:</b> D2916-5
<b>Inspection Dwg:</b> D2916	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

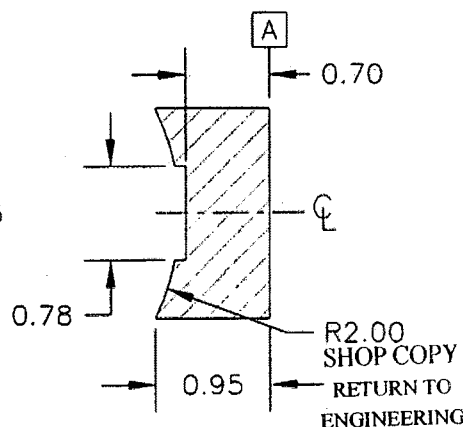
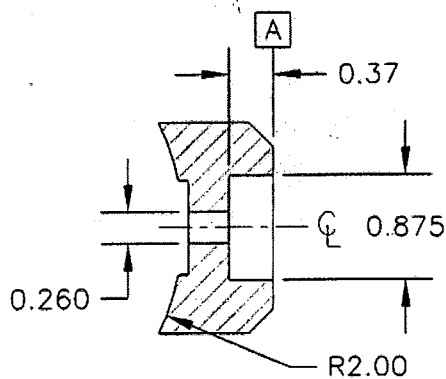
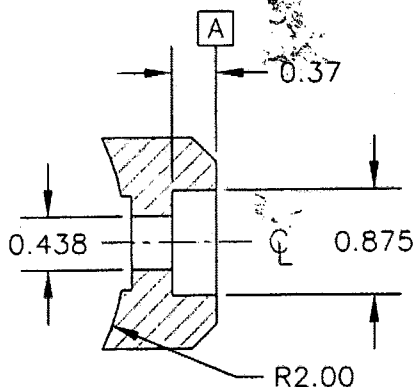
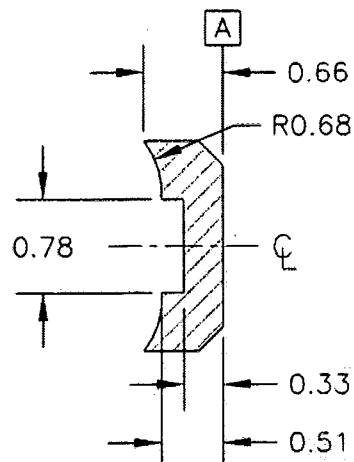
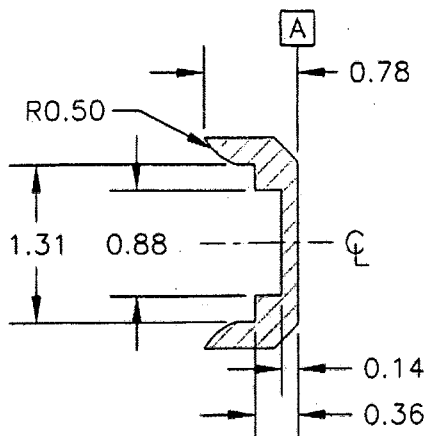
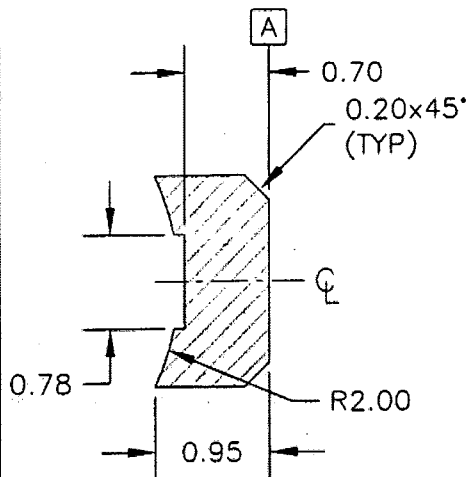
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.75	+/-0.030	1.752	*			
32.13	+/-0.030	32.13	*			
28.94	+/-0.030	28.94	/		Tape	
20.81	+/-0.030	20.81	/		Tape	
7.00	+/-0.030	7.00	/			
5.000	+/-0.010	4.993	/			
13.188	+/-0.010	13.188	/			
30.125	+/-0.010	30.125	/		Tape	
D-D 0.37	+/-0.030	.372	/			
Ø0.438	+0.005/-0.000	Ø.438	/			
0.875	+/-0.010	.870	/			
E-E 0.37	+/-0.030	.372	/			
0.875	+/-0.010	.870	/			
Ø0.438	+0.005/-0.000	Ø.438	/			
JH 1.44	+/-0.030	1.440	/			
0.063	+/-0.010	.070	/			

<b>Measured by:</b> HB / SA	<b>Audited by:</b> J.F.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-6-5 08/06/24	<b>Date:</b> 08/06/24	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D205-665-015	KJ/RF	JH

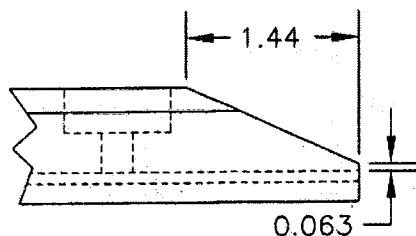


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2916	REV. B SHEET 1 OF 2
DATE 00.02.24		TITLE CABLE GUARD	SCALE 1:6
A	99.09.29	NEW ISSUE	
B	00.02.24	ADD K-K FOR D2521 COMPATIBILITY	



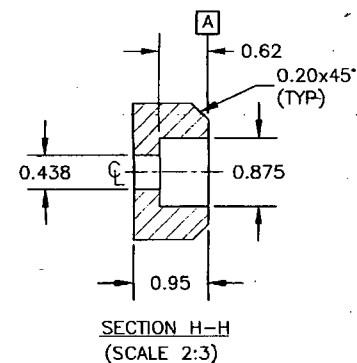
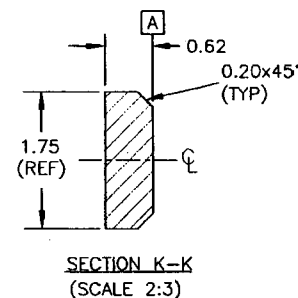
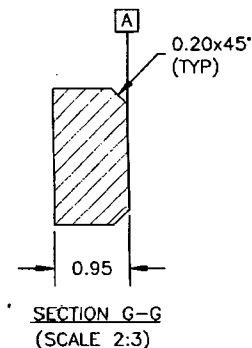
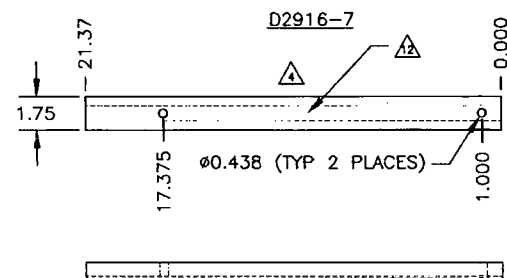
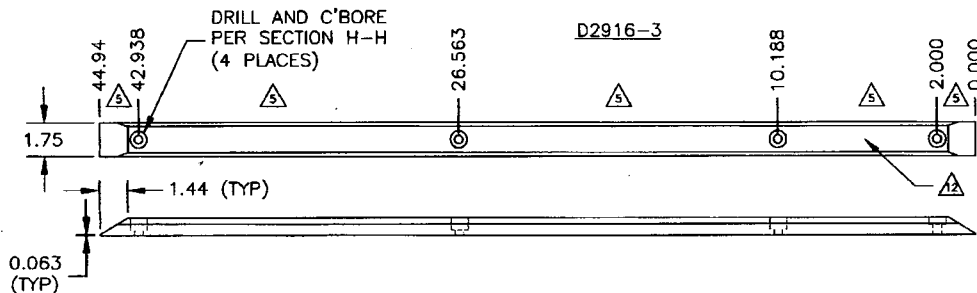
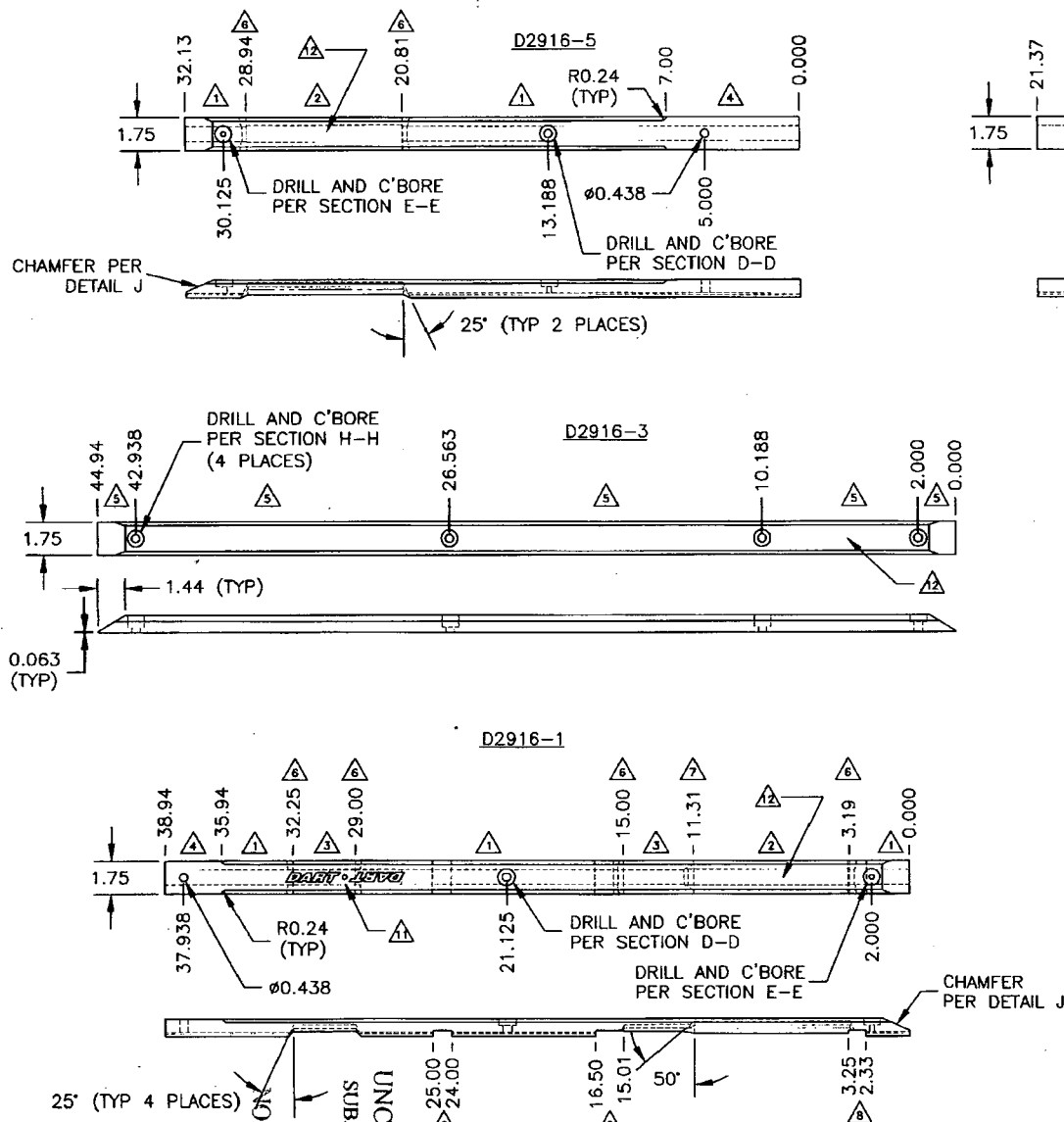
SECTION F-F (SCALE 2:3)

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WITHOUT NOTICE  
WORK ORDER  
NO. 39593



DETAIL J  
(SCALE 2:3)

RELEASED  
00.02.25 DS



- NOTES:**
- 1) MACHINE CONSTANT SECTION A-A
  - 2) MACHINE CONSTANT SECTION B-B
  - 3) MACHINE CONSTANT SECTION C-C
  - 4) MACHINE CONSTANT SECTION F-F
  - 5) MACHINE CONSTANT SECTION G-G
  - 6) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
  - 7) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
  - 8) MACHINE SLOT PER SECTION K-K WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
  - 9) MATERIAL: UHMW BLACK PER SPEC CONTROL DWG D2689
  - 10) BREAK ALL UNMARKED RADII 0.020 TO 0.040
  - 11) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250.
  - 12) ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010.
  - 13) ALL HOLES DRILLED ON CENTERLINES
  - 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 15) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

DESIGN #	DRAWN BY	<b>DART</b> DART AEROSPACE LTD WINDSOR, ONTARIO, CANADA	REV. B
CHECKED	APPROVED	DRAWING NO. D2916	SHEET 2 OF 2
DATE 00.02.24		TITLE CABLE GUARD	SCALE 1:6

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
2515913